SETUP & OPERATION MANUAL

FEATURES & SPECIFICATIONS

- Rotating, 45° tilting, crank-operated worktable with quick release clamp.
- Large front mounted stop switch with lock-out safety feature to prevent unwanted or unintentional start-up.
- Adjustable spindle tension return spring.
- Built-in lamp illuminates the drilling area.
- Spindle is supported by high quality ball bearings.
- Cast-iron pulleys reduce vibration.
- Industrial 1/2 HP motor.
- Heavy-duty positive depth stop for quick adjustment.
- 5/8" drill chuck.

SWING
13 3/8" (340 mm)

DRILLING CAPACITY
5/8" (16 mm)

CHUCK SIZE
5/8" (16 mm)

SPINDLE TRAVEL
3 1/8" (80 mm)

SPINDLE DISTANCE TO TABLE
15 1/4" (387 mm)

SPINDLE DISTANCE TO BASE
32 1/4" (819 mm)

TABLE SIZE
11 3/8" (289 mm)

COLUMN DIAMETER
2 7/8" (73 mm)

NUMBER OF SPEEDS
12

SPINDLE SPEEDS
280-3000 RPM

SPINDLE TAPER
MT 2

OVERALL HEIGHT
38 1/2" (978 mm)

BASE SIZE
10" x 16 7/8" (254 x 429 mm)

MOTOR
1/2 HP, 110 V, 8 A

WEIGHT
105 LBS (48 kg)

14" DRILL PRESS

MODEL #75-030

GENERAL INTERNATIONAL

VERSION 2 - AUGUST 06/12
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GENERAL® INTERNATIONAL
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Telephone (514) 326-1161 • Fax (514) 326-5555 • www.general.ca

THANK YOU for choosing this General International model 75-030 Drill Press. This drill press has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this drill press as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

GENERAL ® INTERNATIONAL WARRANTY

All component parts of General® International Star-Shop machinery are carefully tested and inspected during all stages of production, and each machine is thoroughly inspected upon completion of assembly. Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace, within a period of 24 months from date of purchase, any genuine part or parts which, upon examination, prove to be defective in workmanship or material. In order to obtain this warranty, all defective parts must be returned freight pre-paid to General® International Mfg. Co., Ltd. Repairs attempted without our written authorization will void this warranty.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of drill press and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

Rules for Safe Operation

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate the drill press when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.

2. The working area should be well lit, clean and free of debris.

3. Keep children and visitors at a safe distance when the drill press is in operation; do not permit them to operate the drill press.

4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.

5. Stay alert! Give your work your undivided attention. Even a momentary distraction can lead to serious injury.

6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.

7. Do not wear loose clothing, gloves, bracelets, necklaces and ornaments while the drill press is in operation.

8. Before starting any operation make sure that the head and table lock handles are securely tightened and the head and table support collars are correctly position.

9. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before commencing operation.

10. Keep hands well away from drill bit and all moving parts. Use a hold-down or clamp to secure the stock, and use a brush, not hands, to clear away chips and dust.

11. Be sure the drill bit is securely installed in the chuck before operation.

12. Be sure the drill bit has gained full operating speed before beginning to drill.

13. Always use a clean, properly sharpened drill bit. Dirty or dull bits are unsafe and can lead to accidents.

14. Do not push or force the bit into the stock. The drill will perform better and more safely when working at the rate for which it was designed.

15. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.

16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning, be sure it is properly reattached before using the tool again.

17. Never leave the machine unattended while it is running or with the power on.

18. Use of parts and accessories NOT recommended by General® International may result in equipment malfunction or risk of injury.

19. Never stand on machinery. Serious injury could result if the tool is tipped over or if the drill bit is unintentionally contacted.

20. Always disconnect tool from power before servicing or changing accessories such as a drill bits, or before performing any maintenance, cleaning or adjustments, or if the machine will be left unattended.

21. Make sure that switch is in the "OFF" position before plugging in the power cord.

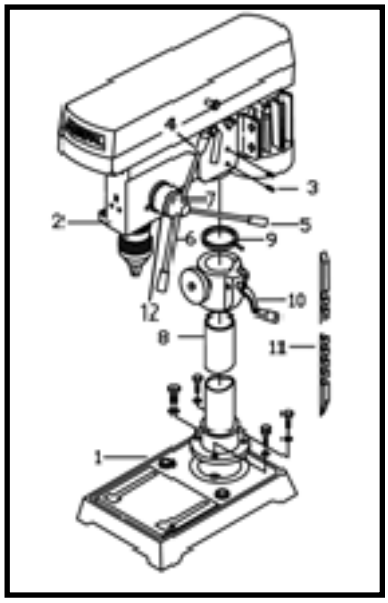
22. Make sure tool is properly grounded. If tool is equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong

14" DRILL PRESS
75-030

ASSEMBLY INSTRUCTIONS

Before proceeding with the assembly, read the operating and maintenance instructions manual and familiarize yourself with correct assembly, setup, maintenance and safety procedures.

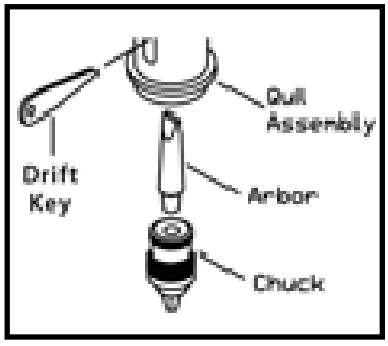
To avoid risk of serious injury, make sure the drill press is installed on a flat, solid and stable surface.



1. Place the base (1) on a flat surface and screw the column (8), to the base.
2. Remove the rack ring (9) from the column (8).
3. Insert the rack (11) into the table bracket and position the 2 pieces onto the column at the same time. The bottom lip of the rack is pressed between the column and the flange. The top lip of the rack is similarly secured with the replacement of the rack ring (9). Tighten the set screw in the rack ring. Place the handle (10) on the worm gear and secure it with the hex head bolt.
4. Attach the head (2) to the column and tighten the head with the set screws (3).
5. Secure the table onto the table arm.
6. Attach the 3 feed handles, (4, 5 & 6), to the handle body (7).
7. If desired, install a max. 60 watt light bulb (not included) for the worklight (12).

Once assembled, clean the protective coating from all surfaces (where applicable) using a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.) A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing painted surfaces, as many solvent-based products will remove paint.

INSTALLING THE CHUCK

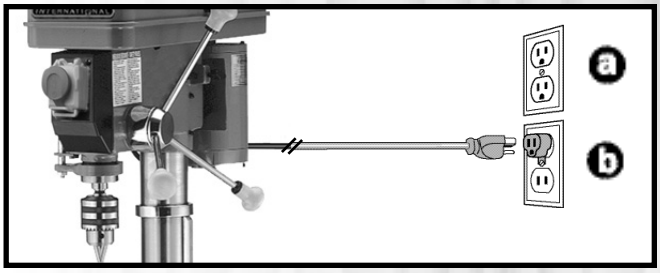


1. Slide the arbor into the quill assembly, flat end goes in first.
2. Slide the chuck onto the tapered end of the arbor and using the feed handle, lower the quill assembly against the table to secure the chuck. (To avoid damaging the chuck place a piece of wood on the table.)

REMOVING THE CHUCK AND ARBOR

1. Turn "OFF" and disconnect the drill from the power source.
2. Using feed handle, lower the quill assembly.
3. Insert tool into, and all the way through the quill assembly.
   Note: It may be necessary to rotate the quill in order to be able to get the tool all the way through.
4. While holding onto the chuck to prevent damage, raise the quill assembly. The arbor and chuck should fall out.

CONNECTING TO A POWER SOURCE



Plug the drill into a proper receptacle. Your power tools should be connected to a dedicated electrical circuit of not less than #14 wire and should be protected with a 15 amp time lag fuse. If an extension cord is needed, use only 3-wire cords with 3-prong grounded-type plugs and 3-pole receptacles.

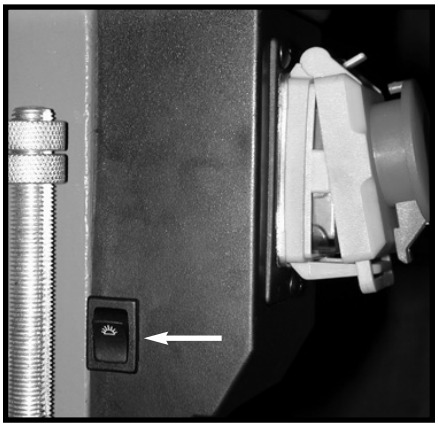
Grounding: This tool must be grounded to protect the operator from electrical shock. The supplied motor recommended for your drill is wired for 110 Volt, single phase, and has a 3-conductor cord and 3-prong grounded plug to fit a grounded-type receptacle, **a**. Do not remove the 3rd prong (grounding pin) from the plug to make it fit into an old 2-hole wall socket. If an adapter plug is used, **b**, it must be attached to the metal screw of the receptacle. Note: Use of an adaptor plug is illegal in some areas. Check your local codes.

Before connecting the motor to the power line, make sure that the switch is in the OFF position and that the electrical current is of the same type as that stamped on the motor nameplate. All electrical connections should have proper contact. Running on low voltage will damage the motor.

ADJUSTMENTS AND CONTROLS

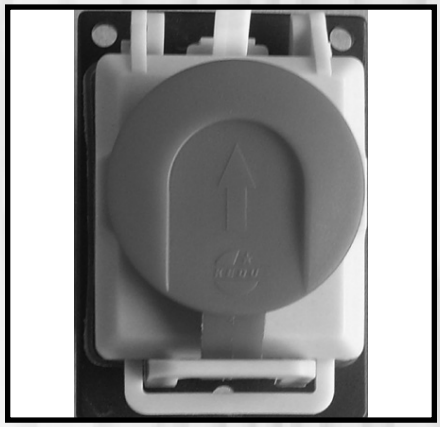
POWER "ON"

1. Make sure the switch is in the "OFF" position and plug the power cord into a matching outlet.
2. Make sure the pulley guard is closed.
3. Check that the chuck or keyless chuck is installed properly.
4. When turning the machine "ON" be aware that the shaft will rotate freely.
5. When the drill press is running check to see if it runs without vibration or shaking.
6. Make sure the table bracket moves up and down smoothly.
7. Make sure the spindle shaft turns smoothly.
8. Unlock the cover, press the green start button for starting machine. Press the red button to stop machine.

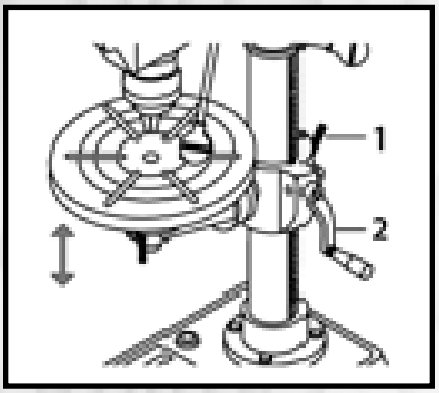


WORK-LIGHT SWITCH

POWER ON



POWER OFF



ADJUSTING TABLE HEIGHT

1. Loosen the column lock handle (1).
2. Turn the crank handle (2) until the table is at the desired height.
3. Retighten the column lock handle (1) before starting.

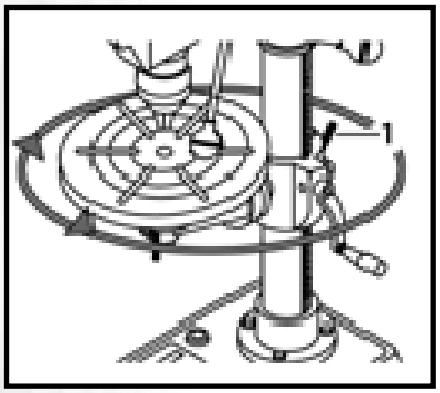


TABLE SWING ADJUSTMENT

1. Loosen column lock handle (1).
2. Swing the table arm bracket and the table to the desired position.
3. Retighten column lock handle (1).

When working with taller work pieces swing the table 180° out of the way and use the base as a table.

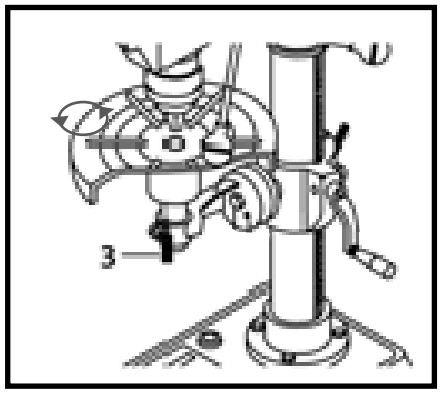


TABLE ROTATION ADJUSTMENT

1. Loosen the table lock handle (3).
2. Rotate the table to the desired position.
3. Retighten the table lock handle (3).

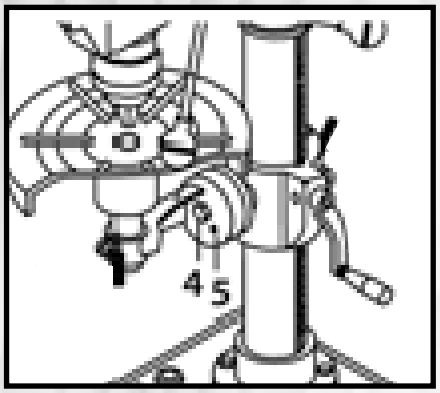
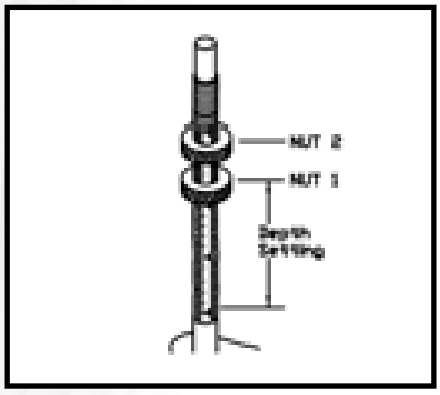


TABLE TILT ADJUSTMENT

1. Loosen the pivot bolt (4) and set screw (5).
2. Tilt the table to the desired angle.
3. Retighten the pivot bolt (4) and set screw (5).



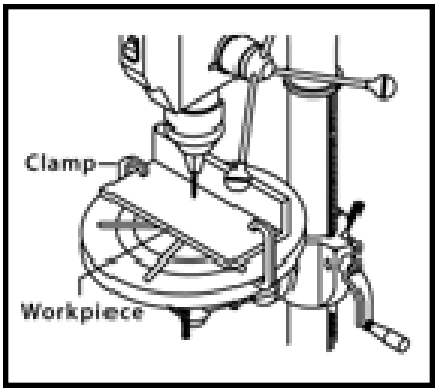
DEPTH STOP ADJUSTMENT

1. Set the bottom edge of nut #1 even with the desired depth setting.
2. Tighten nut #2 against nut #1 to secure it in position.
3. Depth stop is now set and will provide repetitive holes of equal depth.

DRILLING

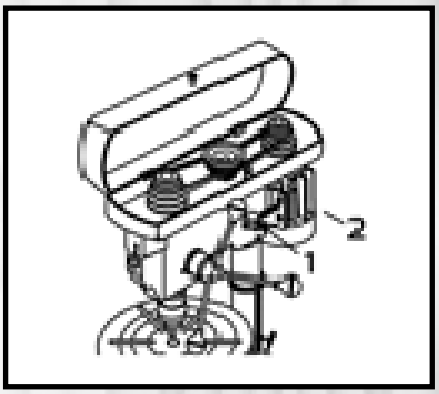
Always use hold-downs or clamps to secure the workpiece. The workpiece should never be held only by hand. Take care to use clean, sharp bits. Damaged or broken bits could result in serious injury. When drilling flat work, place the worpiece on a wooden base and clamp it down against the table.

For working in wood, machine spur bits are generally preferred. Do not use hand bits, which have a screw tip. At drill press speeds these bits rotate into the workpiece so rapidly that they lift the workpiece off the table and swirl it.



CHANGING SPEEDS

MAKE SURE THE DRILL PRESS HAS COME TO A COMPLETE STOP BEFORE CHANGING SPEEDS. REFER TO THE SPINDLE SPEED SELECTION CHART LOCATED ON THE INSIDE OF THE SPINDLE COVER.



1. Disconnect the drill press from the power source.
2. Loosen the slide bar bolt (1) located on the right side of the head.
3. Pull the motor (2) in towards the head to loosen the belts.
4. Relocates belts to the desired pulleys to select a new spindle speed.
5. Push the motor (2) back, away from the head.
6. Retighten the slide bar bolt (1) and check the belt tension.

THE FOLLOWING TABLE CAN BE USED AS A GUIDLINE FOR SELECTING SPEEDS BASED ON BIT SIZE & BIT MATERIAL.

BIT SIZE	BIT MATERIAL				
	CAST STEEL	TOOL STEEL	CAST IRON	MILD STEEL	ALUM. & COPPER
	CUTTING SPEED				
	40 FT/MIN (12 M/MIN)	60 FT/MIN (18 M/MIN)	80 FT/MIN (24 M/MIN)	100 FT/MIN (30 M/MIN)	200 FT/MIN (60 M/MIN)
DIAMETER	REVOLUTIONS PER MINUTE				
1/16" (2 mm)	1910 - 2445 RPM	2865 - 3665 RPM	3820 - 4890 RPM	4775 - 6110 RPM	9550 - 12225 RPM
1/8" (3 mm)	1220 -1275 RPM	1835 -1910 RPM	2445 - 2545 RPM	3055 - 3185 RPM	6110 - 6365 RPM
3/16" (5 mm)	765 - 815 RPM	1145 - 1220 RPM	1530 - 1630 RPM	1910 - 2035 RPM	3820 - 4075 RPM
1/4" (6 mm)	610 RPM	915 - 955 RPM	1220 - 1275 RPM	1530 - 1590 RPM	3055 - 3180 RPM
5/16" (8 mm)	480 - 490 RPM	715 - 735 RPM	955 - 980 RPM	1195 - 1220 RPM	2390 - 2445 RPM
3/8" (10 mm)	380 - 405 RPM	570 - 610 RPM	765 - 815 RPM	955 - 1020 RPM	1910 - 2035 RPM
7/16" (11 mm)	350 RPM	520 - 525 RPM	700 RPM M/MIN)	870 RPM	1740 - 1745 RPM
1/2" (13 mm)	300 - 305 RPM	440- 460 RPM	590 - 610 RPM	735 - 765 RPM	1470 - 1530 RPM

MAINTENANCE

- Keep the unit clean and free of dust and debris. Painted surfaces can be wiped with a damp rag.
- Periodically lubricate (oil or grease) all sliding or moving parts including the column and table tilt mechanisms, brackets, worm gears and the quill.
- Bearings in the quill and the V-belt pulley are sealed, permanently lubricated and maintenance free.
- Lightly oil the slide bars every 2 months.
- If cranking becomes difficult, grease the column bracket.

IMPORTANT: USE ONLY GENERAL INTERNATIONAL OR AUTHORIZED REPLACEMENT PARTS AND ACCESSORIES.

RECOMMENDED OPTIONAL ACCESSORIES

We offer a large variety of products to help you increase convenience, productivity, accuracy and safety when using your drill press Here's a small sampling of optional accessories available from your local General International dealer.

For more information about our products, please visit our website at www.general.ca

25 PIECE - RUBBER DRUM SANDING SET
#75-025

Turn your drill press into a mini drum sander. Ideal for small sanding jobs on curved or odd shaped pieces. Kit includes 5 different sized drums: 1/2", 3/4", 1", 1-1/2" & 2" plus 2 sets of 80 grit and 2 sets of 120 grit sanding sleeves for each.

ABRASIVE SLEEVES
#70-030

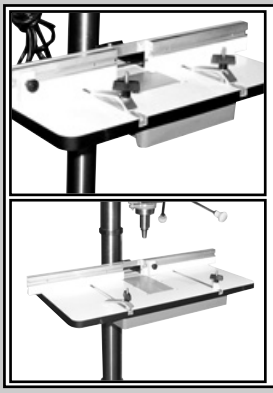
10 piece replacement abrasive sleeve set for 70-025. Includes 5 (one of each size) 80 & 120 grit sanding sleeves.

9" AUGER DRILL BIT SET
#70-105

Heavy duty carbon steel. Heat-treated and precision sharp-ened for quick, accurate and effortless cuts. Includes 6 bits - sizes: 1/4", 5/16", 3/8", 1/2", 5/8", 3/4" with 3/8" shank, in a conve-nient carrying case.

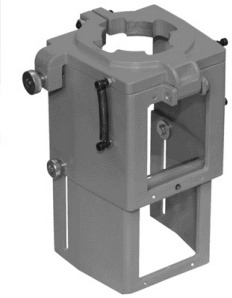
DRILL PRESS TOOL TRAY
#70-125

Can be installed on most drill press columns. Made from durable plastic with a metal swivel rod.

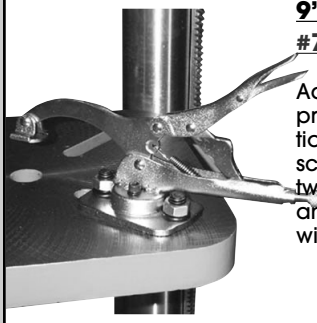


12" X 24" (305 X 610 MM) UNIVERSAL DRILL PRESS TABLE
#70-135
17" X 32" (432 X 813 MM) UNIVERSAL DRILL PRESS TABLE
#70-140
Adds versatility to your drill press and repeatable accuracy to your work. Includes: 3" tall 2-pc. Full length fence with t-slot and stop, 2-1/2" dust port connection, parallel t-slots in table and 2 workpiece holdowns. Mounts to all drill tables with mounting holes.

DRILL PRESS CHUCK GUARD - 70-155



- Prevents unintentional user con tact with the chuck and bit dur ing operations.
- Contains wood chips, shavings or other debris for safer drilling.
- Designed to meet the most strin gent industrial and educa tional safety requirements.
- Sturdy cast aluminum body and pact resistant windows.
- Spring loaded flip-up design, allows for quick drill bit changes without interference.



9" VISE-CLAMP
#70-130

Adjustable lock-in clamping pressure and 360 degree rota-tion; a must for all safety con-scious woodworkers. Includes two 1/2" t-bolts to mount to any drill table with 9/16" (or wider)mounting holes.

DRILL PRESS VISES
#95-140/95-150/95-160

Hold down slots along both sides. High tensile iron cast-ing construction for maxi-mum durability. One-piece cast-iron axial sleeve and movable jaws. Fast action, "Acme" type screw threads.

95-140 (4") / 95-150 (5") / 95160 (6")

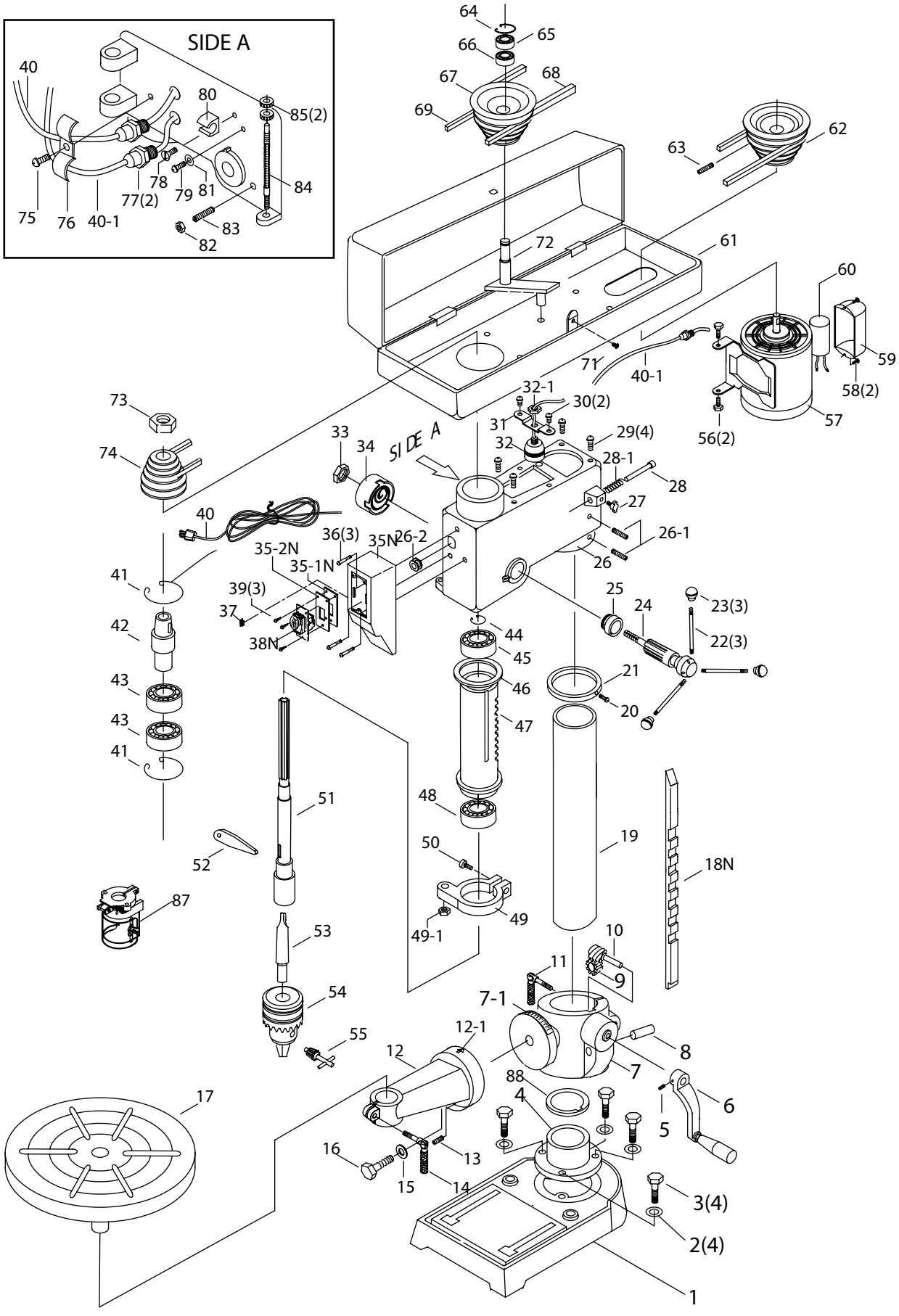
PARTS LIST 75-030

PART N0.	DESCRIPTION	QTY
75025-01	BASE	1
75125-02	WASHER	4
75125-03	BOLT	4
75025-04	BASE FLANGE	1
75125-05	SCREW	1
75125-06	CRANK SLEEVE HANDLE	1
75125-07	TABLE BRACKET	1
75125-07-1	TILT SCALE	1
75125-08	GEAR SHAFT	1
75125-09	HELICAL GEAR	1
75125-10	ELEVATING WORM 1/2	1
75125-11	CLAMP BOLT	1
75125-12	TABLE ARM	1
75125-12-1	POINTER	1
75125-13	SET SCREW	1
75125-14	CLAMP BOLT	1
75125-15	WASHER	1
75125-16	BOLT	1
75125-17	TABLE	1
75025-18N	RACK	1
75025-19	COLUMN 73 X 760	1
75125-20	SCREW	1
75125-21	RACK COLLAR	1
75125-22N	FEED HANDLE	3
75125-23	HANDLE KNOB	3
75125-24N	PINION SHAFT	1
75125-25	SLEEVE	1
75125-26	HEAD	1
75125-26-1	SET SCREW	2
75125-26-2	RUBBER BUSHING	1
75125-27	KNOB	1
75125-28	BELT TENSION ADJUSTMENT ROD	1
75125-28-1	SPRING	1
75125-29	SCREW	4
75125-30	SCREW	2
75125-31	LAMP FRAME	1
75125-32	LAMP HOLDER	1
75125-32-1	NUT	1
75125-33	NUT	1
75125-34	SPRING & CAP	1
75125-35N	SWITCH BOX	1
75125-35-1N	WASHER PAD	1
75125-35-2N	SWITCH MOUNTING PLATE	1
75125-36	SCREW	3
75125-37	LIGHT SWITCH	1
75125-38N	ON/OFF SWITCH	1
75125-39	SCREW	1
75125-40	ELECTRICAL CORD	1
75125-40-1	MOTOR CORD	1
75125-41	SNAP RING	1
75125-42	DRIVER INSERT	1

PARTS LIST
75-030

PART N0.	DESCRIPTION	QTY
75125-43	BEARING	1
75125-44	SNAP RING	1
75125-45	BEARING	1
75125-46	QUILL GASKET	1
75125-47	QUILL	1
75125-48	BEARING	1
75125-49	SUPPORT / CLAMP SEAT DEPTH STOP	1
75125-49-1	NUT	1
75125-50	SCREW	1
75125-51	SPINDLE	1
75125-52	DRIFT KEY	1
75125-53	ARBOR	1
75125-54	CHUCK	1
75125-55	KEY	1
75125-56	BOLT	2
75125-57	MOTOR	1
75125-58	SCREW	2
75125-59	CAPACITOR COVER	1
75125-60	CAPACITOR	1
75125-61	PULLEY GUARD	1
75125-62	MOTOR PULLEY	1
75125-63	SET SCREW	1
75125-64	SNAP RING	1
75125-65	SNAP RING	1
75125-66	BEARING	1
75125-67	MIDDLE PULLEY	1
75125-68	V-BELT	1
75125-69	V-BELT	1
75125-71	SCREW	1
75125-72	SHAFT ASSEMBLY	1
75125-73	NUT	1
75125-74	SPINDLE PULLEY	1
75125-75	SCREW	1
75125-76	CORD CLAMP	1
75125-77	ELECTRICAL CORD / LAMP	1
75125-78	SCREW	1
75125-79	SCREW	1
75125-80	KEY HOLDER	1
75125-81	WASHER	1
75125-82	NUT	1
75125-83	SET SCREW	1
75125-84	DEPTH STOP ROD	1
75125-85	NUT	2
75125-86	DEPTH STOP SUPPORT	1
75125-87	CHUCK GUARD - ITEM# 75-115A (NOT SHOWN)	1
75125-88	COLUMN PLATE	1

DIAGRAM


SIDE A
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58(2)
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40-1
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23(3)
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SIDE A
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36(3)
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35-1N
39(3)
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75-030

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IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.